



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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Fax 613 632-5246

RBEM652V3002101-M-41
Job Sheet 183915



Part No: RBEM652V3002101-M-41

Job Qty: 6 ea

Part Name: Foot Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/28/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEM652V3002101-M Rev B IPP Rev A 18.04.03 New issue DP Verify DD/ IPP Rev. B 18.09.27
drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Small Fab-2		MLL
110	Mill Conv	6 pcs	10/12/18	10/12/18	0.00	0.60	Mill Conv 1		MLL
120	QC	6 pcs	10/12/18	10/12/18	0.00	0.00	QC2 Machining-5		MLL
125	QC	6 pcs	10/12/18	10/12/18	0.00	0.00	QC8 Machining-5		MLL
130	Packaging	6 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3-1		MLL
140	QC21-SA	6 Ea	10/12/18	10/12/18	0.00	0.00	QC21		MLL

Part Op 110 - 1-Position 143 and -45 as shown, apply Loctite Multi Purpose to mating surfaces of item -43 and -45 as per note 8.
Descriptions: -Loctite B 11389833 Exp.: 05/20 2-Drill 0.1240" to 0.1250" hole as shown through center line of item -43 and -45. ***Measure dowel pin prior to drilling to ensure press fit*** as per note 9 and 10. 3-Press fit dowel pin flush with surface as per note 9 and 10 4-Assemble as per DWG. Install thread protecting cap on bolt to prevent bolt from falling out.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91166A250	Flat Washer ØM6	6 Ea (1 ea)	90-Start up Operation	5072697
91280A332	Hex Head Bolt, Steel, M6 x 1 x 22mm Lg.	6 Ea (1 ea)	90-Start up Operation	5072699
98381A471	Dowel Pin	6 Ea (1 ea)	90-Start up Operation	5047617
RBEM652V3002101-M-43 Stud		6 Ea (1 ea)	90-Start up Operation	5123984
RBEM652V3002101-M-45 Stud Extension		6 Ea (1 ea)	90-Start up Operation	5104183
9753K12	Flexible Vinyl Push-on Round Caps for 3/16"-1/4" OD, 1/2" Inside Height	6 (1 ea)	110-Mill Conv	5115741

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91166A250	6	96	0
	91280A332	6	100	0
	98381A471	6	100	0
	RBEM652V3002101-M-43	6	0	0
	RBEM652V3002101-M-45	6	11	0
110-Mill Conv	9753K12	6	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

Part Specifications

Specifications could not be found.

Plex 9/28/18 11:55 AM Dart.lajeunesse.marie



Container No: S127729



Part: RBEM652V3002101 - M - 41

Job No: 183915

Serial No/Batch: S127729

Revision: B

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/14/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

DQA: _____ Date: _____

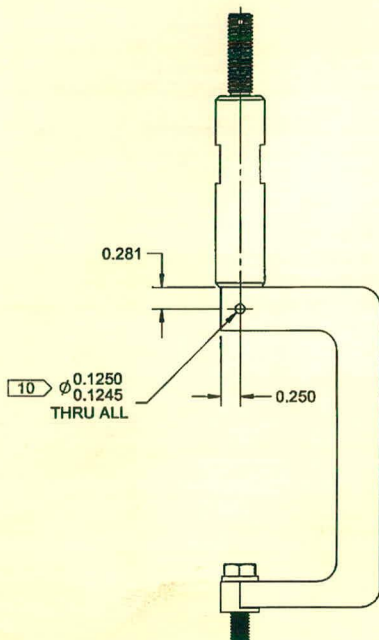
WORK ORDER NON-CONFORMANCE / UPDATE**DART**
AEROSPACE

QA Closed: _____ Date: _____

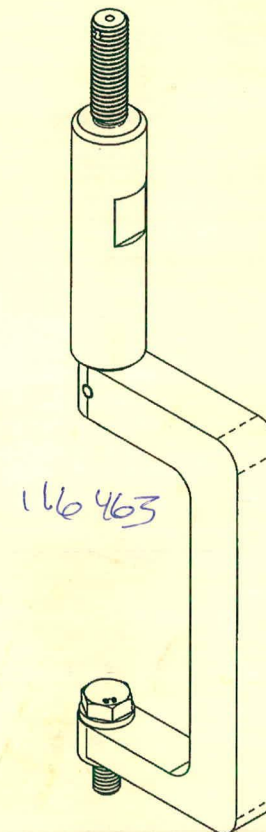
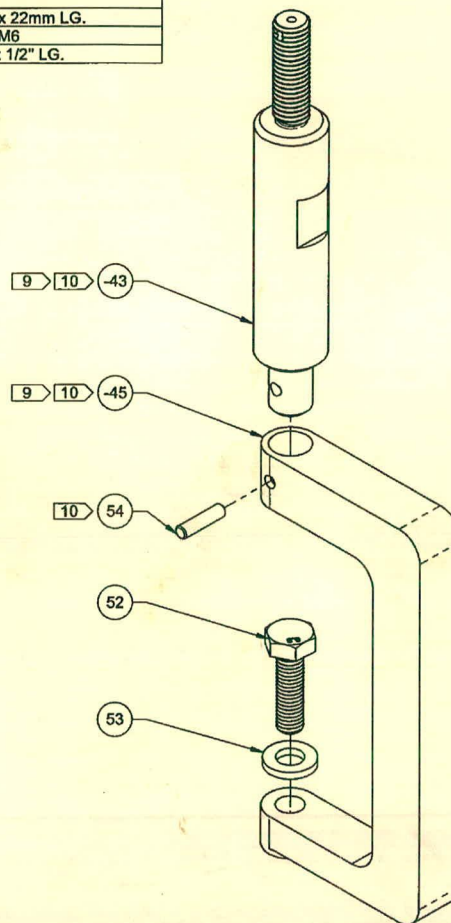
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

ITEM #	QTY	PART #	PART TITLE
-43	1	RBEM652V3002101-M-43	STUD
-45	1	RBEM652V3002101-M-45	STUD EXTENSION
52	1	McMaster#91280A332 OR EQUIV	STEEL HEX HEAD BOLT M6 x 1 x 22mm LG.
53	1	McMaster#91166A250 OR EQUIV	STEEL FLAT WASHER M6
54	1	McMaster#98381A471 OR EQUIV	STEEL DOWEL PIN 1/8" DIA. x 1/2" LG.



DOWEL PIN REMOVED FOR CLARITY



RBEM652V3002101-M-41 FOOT ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM -43 WITH ITEM -45 AND REMOVE EXCESS
- 10) DRILL HOLE AS SHOWN THEN APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 54 WITH ITEMS -43 AND -45 AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBEM652V3002101-M	SHEET 12 OF 17
APPROVED	VM	TITLE	SCALE
DATE 9/25/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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